

Work Order ID 71352-2

Tuesday, June 28, 2011 1:51:00 PM

Page 1

Item ID: D3401-041

Revision ID:

Item Name: Tow Cap Assembly

Start Date: 6/28/2011 Start Qty: 8.00

Required Date: 7/13/2011 Req'd Qty: 8.00

Reference:

Approvals: Process Plan: MF

QC:

Date: 11-06-28

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3401

Rev B

100

0.00



Bandsaw

BAND SAW

0.00

Jeaspa Bandsaw

Memo

Cut Blanks 4.20" Long

110

0.00



Doosan

DOOSAN LATHE

0.00

Doosan Lathe

Memo

Turn as per Folio FA532 & Dwg D3401

Folio Rev: _____

Dwg Rev: _____

Deburr

120

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Quality Control

Memo

0.00

Split

ASAP
for triban

Accept

ASAP



Setup Start

Stop



Cust Item ID:

Customer:



11-06-30

8

11-06-30

8

11-06-30

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71352

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Item ID: D3401-041

Accept



Setup Start



Revision ID:

Item Name: Tow Cap Assembly

Stop



Start Date: 6/28/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/13/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

0.00

Machine as per Folio FA532 and Dwg D3401

Dwg Rev: B

Folio Rev: AA

Identify as D3401-1

Deburr & Buff rad as per Dwg D3401

WR 11/06/30

8 8

135



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

WR 11/06/30

8 8

140



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

WR 11/06/30

8 8

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Setup Start



Revision ID:

Stop



Item Name: Tow Cap Assembly

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Cust Item ID:

Required Date: 7/13/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150



Small Fab

Small Fab

0.00

Memo

0.00

SB 11/07/05

(1)

Small Fab

Drill and c'sink using DT8782 as per Dwg D3401

160



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/11/07/05

(H)

Quality Control

170



HandFinish

Chemical Conversion Coat per QS1005 4.1

0.00

Memo

0.00

1 8/11/07/06

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Setup Start



Revision ID:

Stop



Item Name: Tow Cap Assembly

Start Date: 6/28/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/13/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:45
320°F
11:15

0.00

1X Ø M/LU/07/07

190

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

1 Ø M/LU/07/07

195

Assemble as per dwg

0.00



HandFinish

Hand Finishing

Memo

0.00

1 Ø M/LU/07/07

W/O:		WORK ORDER CHANGES					
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Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/07/07



210

Identify as per dwg & Stock Location: FP-2

0.00



Packaging

Memo

0.00

Packaging

1 of 85 units

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/07/08

MF 11-07-07

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, June 28, 2011 1:50:54 PM

Page 1

Work Order ID: 71352

Parent Item: D3401-041

Parent Item Name: Tow Cap Assembly



Start Date: 6/28/2011

Required Date: 7/13/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A 05.09.01 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6R3.500 Purchased

No

200

f

11.5300

0.35

2.947368



6061 RD bar 3.50

Location

Loc Qty

Loc Code

MAT005

5.86

116808

5.86

MAT036

5.67

110993

5.67

NAS1330C3KB116 Purchased

No

100

Each

710.0000

4



Insert

Location

Loc Qty

Loc Code

ST276

710

102606

200

103185

68

103337

442



2.947368

2.833

CSJ 11/09/02



xd

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DART AEROSPACE USA, INC.,
PORT HADLOCK, WA

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PH

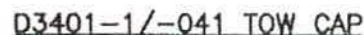
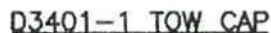
PORT HADLOCK, WA

12

SCALE

1:2

1



1) MATERIAL: MAKE FROM ALUMINUM 6061-T6 Ø3.500 ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-200/8
(REF. DART SPEC M6061T6R3.5000)

2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015

3) ALL DIMENSIONS ARE IN INCHES

4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

1) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

D3401-041 TOW CAP PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3401-1	TOW CAP
4	NAS1330C3KB116	INSERT

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